

Work Order ID 148593

Tuesday, July 05, 2016 3:09:37 PM

148593

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Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 7/12/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/15/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: **DAS** Date: **JUL 12 2016** Tooling: Date: Run Start ***NR1***
 QC: **21** Date: **9-89** SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								

100 Skidtubes 0.00
100
 Skidtubes Memo 0.17
 Skidtubes
 1-Cut D2600-5 to length as per Dwg D2739.
 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
 3-Use uni-bit to open holes to finish size as per Dwg D2739.
 4-Bevel Fwd end of extrusion and Deburr holes and ends.
 5-Deburr

10 08 - 11 R.L

120 Chemical Conversion Coat per QSI005 4.1 0.00
120
 HandFinish Memo 0.10
 Hand Finishing

(5) 2016/08/12
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				5	0	16-08-23		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <u>LG002</u> Memo LOCATION : LG002	0.00 0.01				5	0	BE 16-08-23		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.08								DAS 21 9-89 AUG 2 4 2016 Jem 16/08/23

DQA: _____ Date: _____

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 148593

148593

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 7/12/2016

Required Date: 7/15/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No				Each	26.0000		5			
D2600-5-108									**				
Extrusion 'I Beam' thin													

Location

HALL

112593

Loc Qty

26

26

Loc Code

DQA: _____ Date: _____

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